

Work Order ID 85094

85094

Page 1

June-01-12 3:42:44 PM

Item ID: D350-578-021

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bearpaw

Stop *NS2*

Start Date: 01/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/04 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2672

Rev B1

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-021 CHG005

160

0.00

160

Packaging

Packaging

Memo

0.00

Packaging

Pick: Packing Kit
(Note: D2672B is on the BOM as material from step 3)

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

DAS 16 12/07/13

MLJ 12-7-10 (4)

4

12/07/10 JB

DAS 16 12/07/13

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85094***85094***

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 01/06/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 4.00 ***4***

Customer:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-021

Identify and Stock

Location: NVA

190

0.00

190

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

Chp 1/1312/7/17MF12-07-13

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Picklist Print

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Page 1

Work Order ID: 85094

85094

Parent Item: D350-578-021

D350-578-021

Parent Item Name: Bearpaw

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 07-01-02 JLM

IPP Rev:B New Manufacturing Method 08-10-29 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2672		Manufactured	No			100	Each	1.0000		8			
-------	--	--------------	----	--	--	-----	------	--------	--	---	--	--	--

Sy *D2672*
Bearpaw 13" X 24", 206

** 85094 *JB*

Location	Loc Qty	Loc Code
----------	---------	----------

ST495

1

73110

1

AN4-17A		Purchased	No			160	Each	580.0000		48			
---------	--	-----------	----	--	--	-----	------	----------	--	----	--	--	--

Sy *AN4-17A*
Bolt

** 12 *JB*

Location	Loc Qty	Loc Code
----------	---------	----------

ST358

300

116704

0

121541

300

ST359

280

112314

0

121011

200

121068

80

AN960JD416	NAS1149D0463J	Purchased	No			160	Each	30.0000		96			
------------	---------------	-----------	----	--	--	-----	------	---------	--	----	--	--	--

Sy *AN960JD416*
Washer

** 24 *JB* 121912 12/07/10

Location	Loc Qty	Loc Code
----------	---------	----------

ST351

30

116289

10

119097

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Work Order ID: 85094

Parent Item: D350-578-021

Parent Item Name: Bearpaw

85094

D350-578-021

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2182B

Manufactured No

160 f

128.5952 2.5 10 ✓

D2182B

Rubber Cushion

**

JB 80

Location

Loc Qty

Loc Code

ST410

128.59517

63413

1.6

66063

41.61817

73932

85.377

73932

(D2182B050) 6 X 5.00" PER KIT

D2274

Manufactured No

160 Each

623.0000 12 48 ✓

D2274

Radius Block

**

JB 80

Location

Loc Qty

Loc Code

ST007

623

78233

2

81958

160

83258

210

84199

251

84199

D2438

Manufactured No

160 Each

84.0000 6 24 ✓

D2438

Clamp

**

86871 JB 12/07/10

Location

Loc Qty

Loc Code

ST456

84

77038

6

83265

28

83266

50

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Parent Item: D350-578-021

D350-578-021

Parent Item Name: Bearpaw

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2529

Manufactured No

160

Each

761.0000

******  ******

48

✓

JB



D2529

Washer

Location

Loc Qty

Loc Code

ST010

761

79485

18

81873

243

84435

500

84435

MS2104214


Purchased

No

160

Each

3,910.000

******  ******

48

✓



JB

12/07/10

MS210421 4

Nut

Location

Loc Qty

Loc Code

ST300

3910

119075

116

121011

537

121444

2957

121652

300

121444

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RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 85094 M25 12/00/07

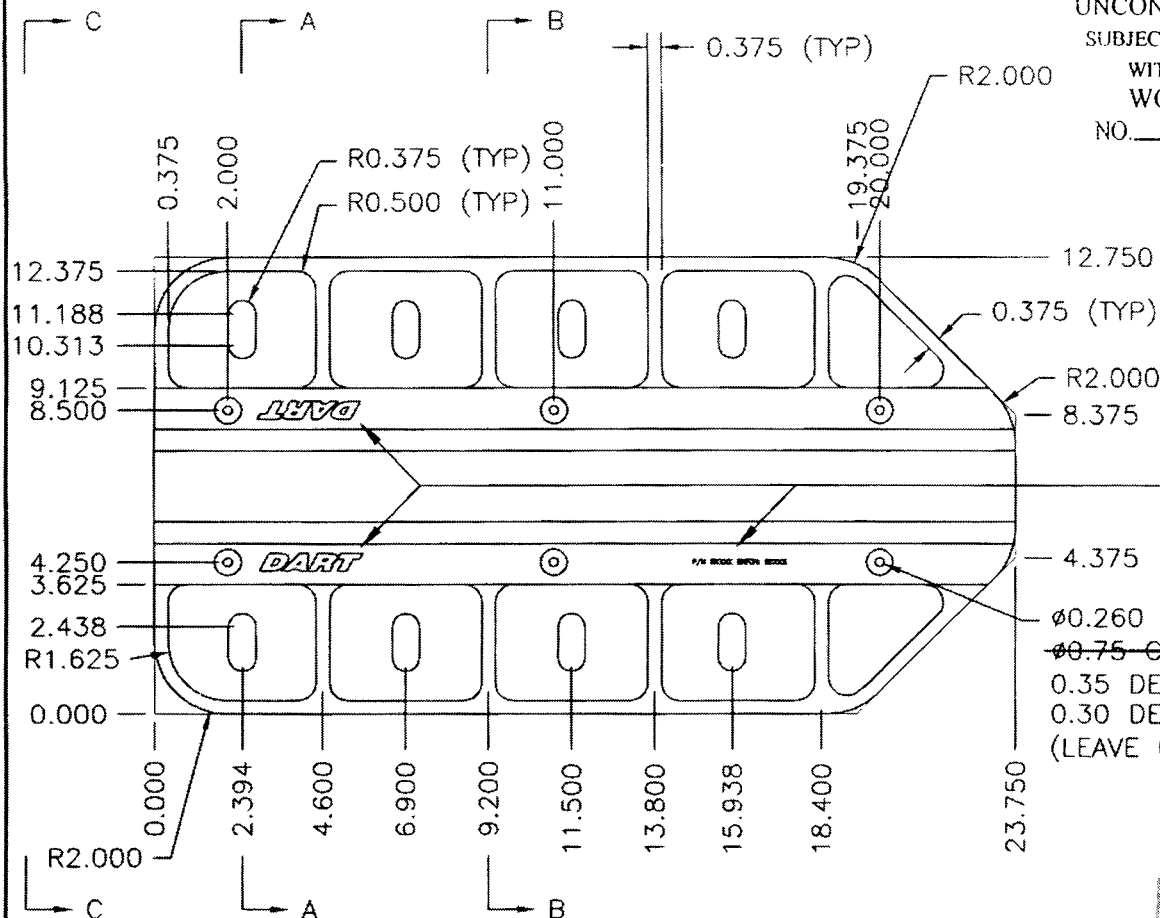
ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)




DART



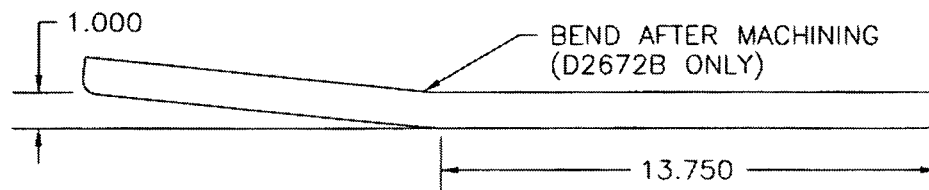
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2672	REV. B SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	97.04.08	NEW ISSUE	
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	
B1	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

Copyright 1997 by DART AEROSPACE LTD



00.260 (TYP) 
~~00.75 C'BORE~~  0.43 C'BORE
 0.35 DEEP FROM TOP (MIN.)
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.300 MIN.) 

FLAT PATTERN



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

EFFECTIVE DEOS

99-06-17 KE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

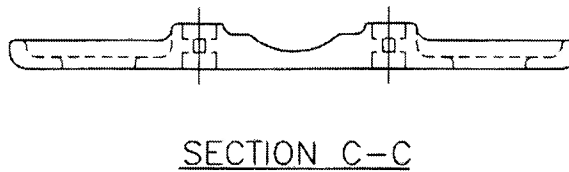
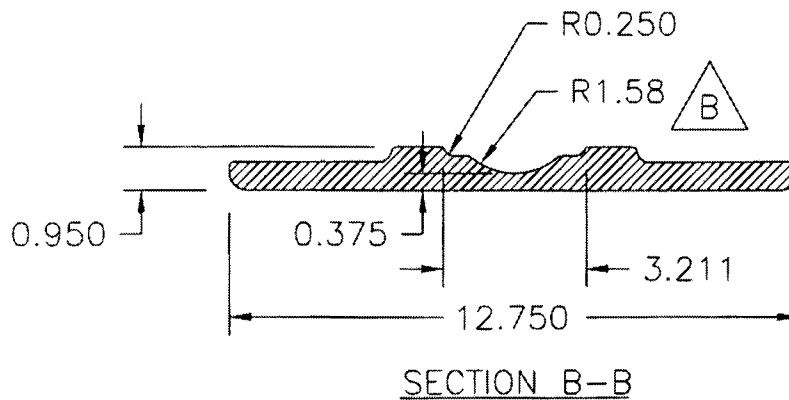
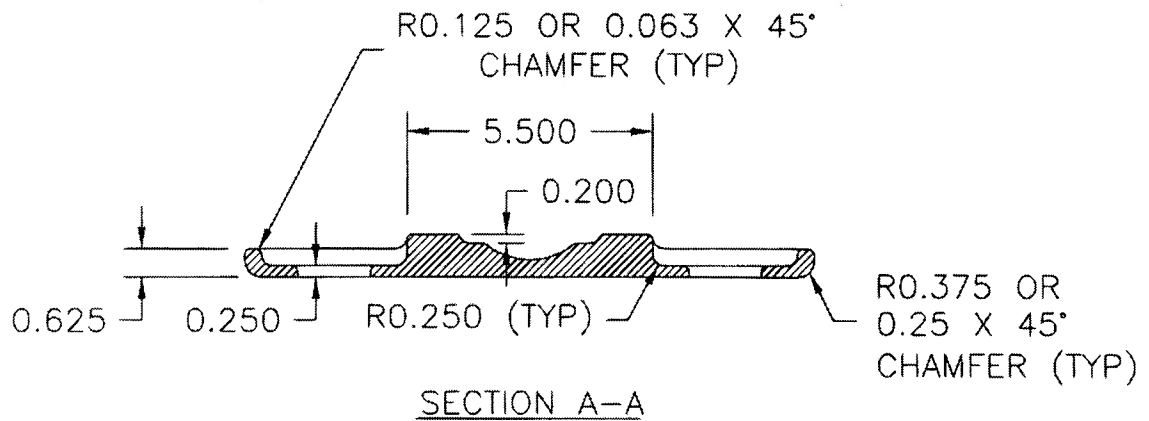
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NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MM</i>	APPROVED <i>KE</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.05.17 KE



85094

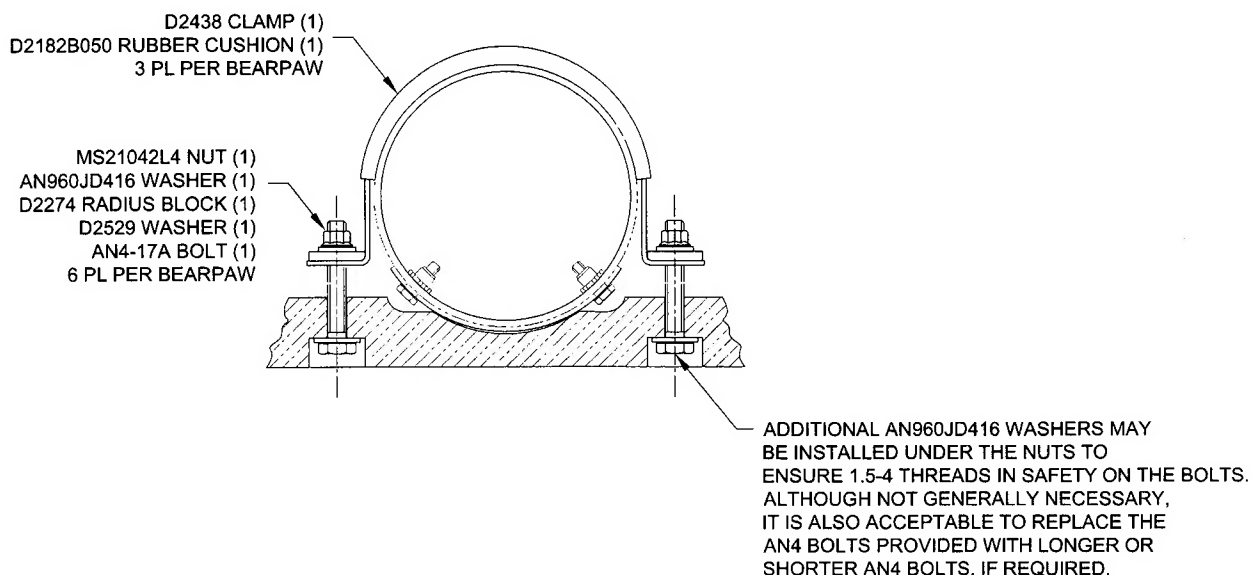
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Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)